Friday, 11/18/2005 5:52:31 PM

User:

Linda Lacelle

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Drawing Name

Job Number

: 24898

Estimate Number

: 10008

P.O. Number

Prsht Rev.

First Issue

: NIA

: 11/18/2005 This Issue

: NC

: N/A : 10005

S.O. No. : N/M

: MACHINED PARTS

Part Number **Drawing Number**

: D2591 - D2591 REV D

Project Number Drawing Revision

: NIA : D

: LUG

Material **Due Date** : pip : 12/15/2005

50 Um:

Each

4D5 532

+1 60

110

Written By

Comment

Previous Run

Checked & Approved By

: Est Rev:I Removed from 9 Digit 05-10-25 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

ASTM A21 Steel .75"x2.5"

1.0

2.0

3.0

M1010B0750X02500

Description:

0.2340 f(s)/Unit Total: 11.7000 f(s) Comment: Qty.:

Oty: 0.2340 f(s)/Unit rotal 11.7000 (c)
ASTM A36 Steel bar 2.50" x 0.75" thick(M1010-B0.750X02.500)

Batch: M17628

BAND SAW



Comment: BAND SAW

Cut blanks: 2.700" long

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA 039 and Dwg D2591

2-Deburr if required

INSPECT PARTS AS THEY COME OFF MACHINE

05.12.03

4.0



ARTS AS THEY COME OFF MACHINE

Comment: INSPECT

SECOND CHECK



5.0

QC8



Comment: SECOND CH

05/12/09

Page 1

Form: rprocess

NCR:			WORK ORDER NON-CONFORMANCE (NCR)									
	DATE	STEP		ption of NC ection A	Initial	Corrective Action Action Desc	ription	Sign &	Verification Section C	Approval Chief Eng	Approval QC Inspector	
0	5,12.05	3	44.	le machining	GIEVO	Scray desta	af	20 S. 205	05-12-05	desto	15.12.05	
- Landing Comments of the Comm				 	1							
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NOTE: Date & initial all entries

Friday, 11/18/2005 5:52:31 PM Date: User: Linda Lacelle **Process Sheet Drawing Name: LUG** Customer: CU-DAR001 Dart Helicopters Services Job Number: 24898 Part Number: D2591 ∕Job Number: Description: Seq.#: Machine Or Operation: PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock (205/12/12 50 Location: WS 10 DOCUMENT CONTROL 7.0 Comment: DOCUMENT CONTROL Inspection Level 21 Job Completion

Dart Ae		1		\$ 5	\A/	OPK OPDED CI	JANGES	<u> </u>				<u>,* </u>	
W/O:	·, ·	-			VV	WORK ORDER CHANGES				1	Annount		
DATE	STEP			PRO	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector	
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Part No):		Р	AR #:	Fault Cat	egory:		ICR: Yes	No DQ	۱:	_ Date: _		
ì				٠ ٢	• •			QA: I	N/C Closed	l: <u> </u>	_ Date: _		
NCR:		1		V	VORK ORE	DER NON-CONF	ORMAN	CE (NC	R)				
DATE	STEP	1 .	Description	of NC		Corrective Action	Section B		Verific	ation	Approval	Approval	
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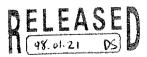
H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

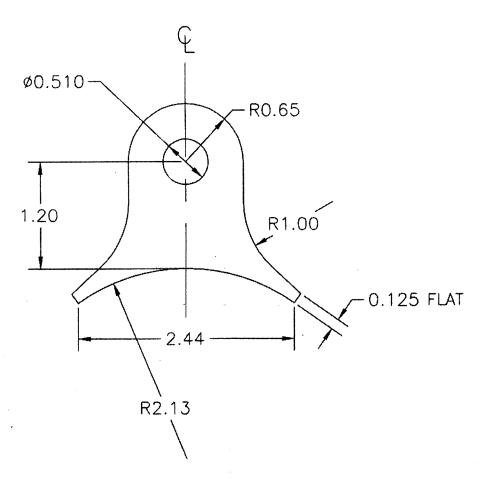
NOTE: Date & initial all entries





DESIG	noy	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECK	(ED	APPROVED	DRAWING NO.	REV. D
	LE	800	D2591 SHEET	1 OF 1
DATE	<u></u>	4	TITLE	SCALE
98.0	1.21		GHW LUG	1:1
 Α		96:09:16	NEW ISSUE	
В		97:06:17	RE-DESIGN TO FLAT BOTTOM	
С		97.12.12	RE-DESIGN TO RADIUS BOTTOM	
D		98.01.21	0.125 FLAT WAS 0.067 FLAT	





0.063 \$ 00.04.05

BREAK ALL SHARP CORNERS 0.010 TO 0.020
MATERIAL: ASTM A36 STEEL 0.50 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
PART IS SYMMETRIC ABOUT CENTER—LINE
ALL DIMENSIONS ARE IN INCHES

DART AEROSPACE LTD	Work Order:	24898
Description: GHW Lug	Part Number:	D2591
Inspection Dwg: D2591 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.20	+/-0.030	1.205	1.			
Ø0.510	+/-0.010	Ø/5103				
0.125	+/-0.010	.125				
2.44	+/-0.030	2.430				
0.65	+/-0.030	2.430				
0.50	+/-0.030	.504				
•						
,						
		*				

Measured by:	Audited by:	Prototype Approval:	N/A
Date: 05.12.05	Date: CS-17-05	Date:	N/A

Rev	Date	Change		Revised by	Approved
Α	04.08.12	New Issue	P/O D205-641-011 & DSI 9161-011	KJ/JLM	

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Job Costing Report

Dart Aerospace Ltd.	•	-	-	Nov 18, 2	005
Hawkesbury				09:21 am	

•				
Work Order No	: 0024898			
Project Name	: D2591		Department Cod	e:
Project For	: WK550		Burden Flags	: NNNNNNN
Work Order Type	: Main		WO Status	: Open
Main WO Number	:		Invoice State	: Not Invoiced
House Part Number	: D2591		Invoice Date	:
Description : Lu	ıg		Invoice Number	: ,
Manufactured : Ye	es		Invoice Amount	: 0.00
Amount Req'd:	* 50	* .	3	
Amount Done :	. 0		Order Entry No	·:
Start Date	: 11-18-05	4	OE Value	: 0.00
Est Finish Date	: 12-15-05			
Act Finish Date	:	*	Est Margin	: 0.000%
Drawings Reqd	: No		Actual Margin	: 0.000%
Ok for Approval	:			
Approval Rec'd	:		\$0 Posted to F.	inished Goods

	* 	Esti	mated	Actual	Var. %	Posted	To Post
	Material Cost	: 14:	0.00	0.00	0.00	₹ o:00. Y) O O O
	Engineering Hours	:	0.00	0.00	0.00	190 - Y	
	Engineering Cost	:	0.00	0.00	0.00	0.00	0.00
•	Production Hours	:	0.00	0.00	0.00	Section in	•
	Production Cost	:	0.00	0.00	0.00	0.00	0.00
	Packaging Hours	:	0.00	0.00	0.00		1
	Packaging Cost	:	0.00	0.00	0.00	رَبِر 0.00	0.00
	OverHead Hours	:	0.00	0.00	0.00	. 25-2	·
	OverHead Cost	:	0.00	0.00	0.00 🛂	0.00	0.00
	CNC Hours	:	0.00	· 🐉 0.00	0.00	1.14 11	
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	Misc. Hours	:	0.00	.0.00	0.00		- ₹. * 1 }
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	Total Cost	:	0.00	0.00	0.00		
	Margin	:	0.000	0.000		•	X .3
	Selling Cost	:	0.00	0.00		**	
				•			1 July 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2

		Estimated	Actual
Labour Hrs/Amount Done	: .	0.00	0.00
Profits/(Loss)	:	0.00	0.00